



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D206-642-151
Job Sheet 187054



Part No: D206-642-151

Job Qty: 1 ea

Part Name: Replacement Skidtube, Low Gear with Run-on Landing Fits LH or RH



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/27/18

Job Tracking No:

Due Date: 12/19/18

Created By: Jesse White

Type: SOLD

Description:

Note: DWG D3804 REV A(DEO), IIN-D206-642 REV Q SHEETS 13,26 IPP REV:A 10.12.08 PER IIN REV.N DD
VERF:EC IPP REV:B 11.09.16 PER IIN REV.O DD VERF:EC IPP Rev:C 12.11.22 now swage per ecn12-679
DD verf:JLM IPP Rev:D 14.04.24 ECN14-520 DD verf:JLM IPP Rev:E 16.04.04 as per CHG004(ecn16-553)
DD verf:JLM

Ship Via:



1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S134037



Part: D206-642-151

Job No: 187054

Serial No/Batch: S134037

Revision:

Inspector:

Exp Date:

Instructions: TC STC SH98-4 Issue 2, FAA STC SA00475SE 15/10/28, EASA STC

QA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

Job Routing									
Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	12/19/18	12/19/18	0.00	0.00	Start Up Skid tubes-1		BB
110	Skid tubes	1 pcs	12/19/18	12/19/18	0.00	1.82	Skid tubes-2		BB
120	QC	1 pcs	12/19/18	12/19/18	0.00	0.00	QC5		PD 19-01-02
130	QC	1 pcs	12/19/18	12/19/18	0.00	0.00	QC9		PD 19-01-02
140	HandFinish	1 pcs	12/19/18	12/19/18	0.00	0.33	HandFinish1		BBB 18-01-02
150	QC	1 pcs	12/19/18	12/19/18	0.00	0.00	QC7-1		DE
160	Skid tubes	1 pcs	12/19/18	12/19/18	0.00	2.00	Skid tubes-2		Jay
180	Skid tubes	1 pcs	12/19/18	12/19/18	0.00	1.82	Skid tubes-2		Jay
190	QC	1 pcs	12/19/18	12/19/18	0.00	0.00	QC5		DE
200	Skid tubes	1 pcs	12/19/18	12/19/18	0.00	2.84	Skid tubes-2		DE MCG
215	QC	1 pcs	12/19/18	12/19/18	0.00	0.00	QC9		CPL DAS
230	QC	1 pcs	12/19/18	12/19/18	0.00	0.00	QC5		38
240	HandFinish	1 pcs	12/19/18	12/19/18	0.00	0.78	HandFinish2		AB 10/1/14
250	Powdercoat	1 pcs	12/19/18	12/19/18	0.00	0.25	Powdercoat1		DEB 19-01-15
260	QC	1 pcs	12/19/18	12/19/18	0.00	0.00	QC3		DE 19-01-16
270	HandFinish	1 pcs	12/19/18	12/19/18	0.00	0.60	HandFinish4		DE 19-01-16
280	HandFinish	1 pcs	12/19/18	12/19/18	0.00	0.60	HandFinish3		DAS
290	QC	1 pcs	12/19/18	12/19/18	0.00	0.00	QC3		JAN 17 2019 68 DAS
300	QC	1 pcs	12/19/18	12/19/18	0.00	0.00	QC5		JAN 17 2019 68 DAS
310	Packaging	1 pcs	12/19/18	12/19/18	0.00	0.00	Packaging3-1	DAS	DAS 60 9-89
315	DC	1 pcs	12/19/18	12/19/18	0.00	0.00	DC	21	DAS 60 9-89
320	QC21-FG	1 Ea	12/19/18	12/19/18	0.00	0.00	QC21	9-89 DAS	JAN 17 2019

Part Op 110 - 1-Deburr Fwd edge of tube 2- Remove ridge on inside of Fwd edge of tube as per Dwg D3804 3-Weld Fwd Cap as Descriptions: per Dwg D3804. Use aluminum rod. Grind D2647 to fit as required.

160 - 1-Open holes of detail B to finished size as per Dwg DEO D3804, (without cutting fluid) 2-C'sink one crossbolt spacer hole as per Dwg D3804 DEO Detail B (without cutting fluid) 3-Deburr and blow out all chips from inside the tube
180 - 1-Locate, install and rivet doublers as per Dwg D3804. Micro-shave rivets as required 2-Bond D2654-1 web in place as per QSI 015. Ensure holes line up. Allow 12 Hrs. cure time before cutting

200 - 1-Remove alodine in one area see DEO Detail B from around hole and prepare for welding 2-Prep per QSI 005 and Insert one D2649 crossbolt spacer. Weld as per QSI 004 and Dwg D3804. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

250 - Make sure Nut Plate Thread is protected using paint screw, and mask GHW studs. START TIME: _____

270 - 1-Install D2651-3 O-Rings on D2651-1 plugs with Petroleum Jelly and install plugs as per Dwg D3804. Clean excess adhesive. 2- Install D2680-041 Nut Plate as per Dwg D2650

280 - 1-Install D2646 Aft Cap and seal with Sikaflex. Clean excess adhesive

310 - Identify and pack for shipping as per PPP D206-642-151 Location :FG107

315 - Photocopy bluefile & type labels per PPP D206-642-151 CHG004

138997 START: 3:30 TEMP: 320° FINISH: 4:00

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OTHER : _____					

007516

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2620	Skidtube, 206 Skidtube	1 Ea (1 ea)	90-Start up Operation	508902
D2647	Cap	1 Ea (1 ea)	90-Start up Operation	5038805
CCR264SS3-3	Cherry Rivet	2 Ea (2 ea)	180-Skidtubes	FM1135622
CR3212-4-03	Cherry Rivet	2 Ea (2 ea)	180-Skidtubes	FM11378864
CR3212-4-04	Cherry Rivet	52 Ea (52 ea)	180-Skidtubes	5045670
D2654-1	Web	1 Ea (1 ea)	180-Skidtubes	25049486
D3286-1	Doubler	2 Ea (2 ea)	180-Skidtubes	50601335
D2649	Cross Bolt Spacer	1 Ea (1 ea)	200-Skidtubes	5050570
D3286-3	Spacer	2 pcs (2 ea)	200-Skidtubes	F91160
D4720-1	Spacer	18 Ea (18 ea)	200-Skidtubes	5030687
D2651-1	Plug	6 Ea (6 ea)	270-HandFinish	5044163
D2651-3	O-Ring	6 Ea (6 ea)	270-HandFinish	5027483
D2680-041	Nut Plate	1 pcs (1 ea)	270-HandFinish	F150426
AN3-37A	Bolt	7 Ea (7 ea)	280-HandFinish	5130484
D2646	Aft Cap	1 Ea (1 ea)	280-HandFinish	M163251-102
D3805-041	Run-on Landing Wearplate Fwd	1 Ea (1 ea)	280-HandFinish	5143283
D3805-045	Run-on Landing Wearplate Aft	1 Ea (1 ea)	280-HandFinish	5143329
D3873-1	Bushing	14 Ea (14 ea)	280-HandFinish	5137516
MS21042L3	Nut	7 Ea (7 ea)	280-HandFinish	5094597
MS27039-1-08	Screw	2 Ea (2 ea)	280-HandFinish	5043210
MS27039-4-06	Screw	1 Ea (1 ea)	280-HandFinish	FM1379511
NAS1149D0332J	Washer	2 Ea (2 ea)	280-HandFinish	5100407
NAS1149D0363J	Washer	7 Ea (7 ea)	280-HandFinish	5123428
NAS1149D0463J	Washer	1 Ea (1 ea)	280-HandFinish	5124987

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2620	1	10	0
	D2647	1	22	0
180-Skidtubes	CCR264SS3-3	2	306	0
	CR3212-4-03	2	182	0
	CR3212-4-04	52	675	0
	D2654-1	1	10	0
	D3286-1	2	38	0
200-Skidtubes	D2649	1	106	0
	D3286-3	2	14	0
	D4720-1	18	288	0
	D2651-1	6	232	0
270-HandFinish	D2651-3	6	609	0
	D2680-041	1	37	0
	AN3-37A	7	76	0
280-HandFinish	D2646	1	50	0
	D3805-041	1	0	0
	D3805-045	1	1	0
	D3873-1	14	93	0
	MS21042L3	7	2,231	0
	MS27039-1-08	2	346	0
	MS27039-4-06	1	31	0
	NAS1149D0332J	2	1,806	0
	NAS1149D0363J	7	1,986	0
	NAS1149D0463J	1	4,505	0

Part Specifications

Specifications could not be found.

Plex 11/27/18 9:52 AM dart.white.jesse

QA: _____ Date: _____



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OTHER :					

ITEM	Qty -041	Qty -043	Part Number	Description
1	X		D3804-041	SKIDTUBE ASSEMBLY, 206 A/B LOW
2		X	D3804-043	SKIDTUBE ASSEMBLY, 206 A/B HIGH
5	1	1	D2600-1-160	EXTRUSION
6	1	1	D2646	AFT CAP
7	1	1	D2647	CAP
8	19	20	D2649	CROSS BOLT SPACER
9	6	8	D2651-1	PLUG
10	6	8	D2651-3	O-RING
11		1	D2654-3	WEB
12	1		D2654-1	WEB
13	1	1	D2680-041	NUT PLATE
14	2	2	D3286-1	DOUBLER
15	2	2	D3286-3	STUD
21	2	2	AN960JD10L	WASHER
22	1	1	AN960JD416	WASHER
23	2	2	CCR284SS3-3	RIVET
24	2	2	CR3212-4-03	RIVET
25	52	52	CR3212-4-04	RIVET
26	2	2	MS27039-1-08	SCREW
27	1	1	MS27039-4-06	SCREW

NOTES

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: 12.5 lb
- 9) WELD PER DART QSI 004
- 10) BENDING: DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 12) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)

DEO ATTACHED

RELEASED

per Ecn 09-536

A	NEW ISSUE	MB	08.07.07
REV.	DESCRIPTION	BY	DATE
DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO.	REV. A
MFG. APPR.	91	D3804	SHEET 1 OF 5
APPROVED	91	TITLE	SCALE
DE APPR.	91	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

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Root Cause		FAULT CATEGORY			
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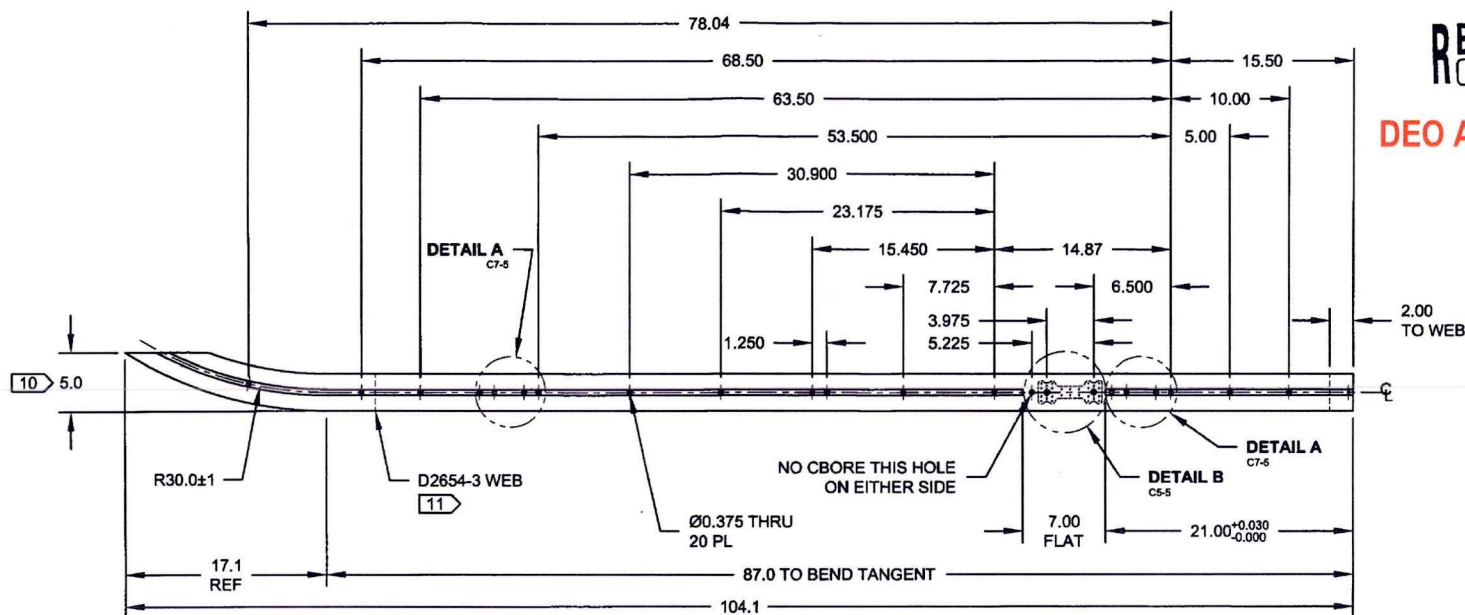
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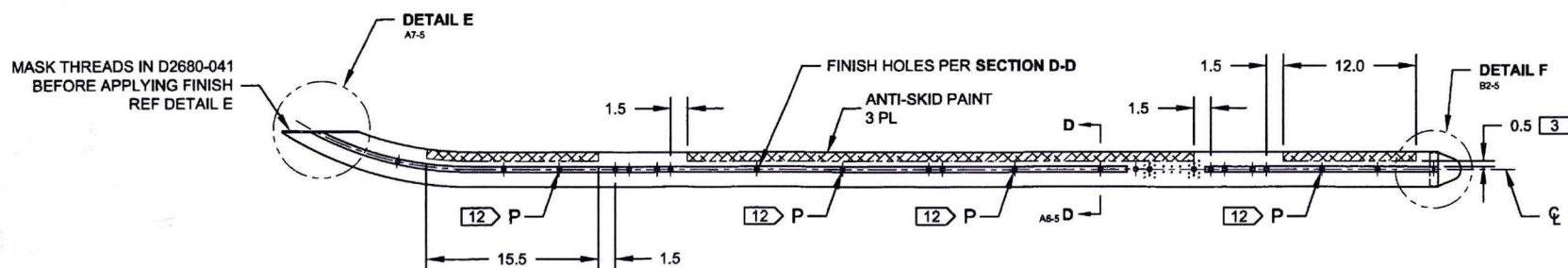
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																			
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OTHER : ☐																																																																							

RELEASED
09.03.03

DEO ATTACHED



D3804-043 BENDING/DRILLING DETAIL



D3804-043 ASSEMBLY/FINISHING DETAIL

DESIGN	97	DART AEROSPACE USA, INC
DRAWN	97	PORT HADLOCK, WA
CHECKED	97	DRAWING NO. D3804
MFG. APPR.	97	REV. A
APPROVED	97	SHEET 3 OF 5
DE APPR.	97	TITLE SKIDTUBE ASSEMBLY, 206A/B
DATE	08.07.07	SCALE NTS

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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

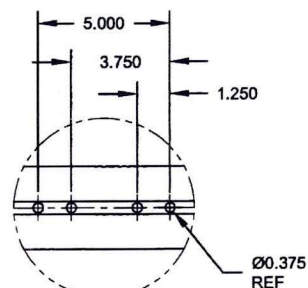
QA Closed: _____ Date: _____

Work Order update only ☐

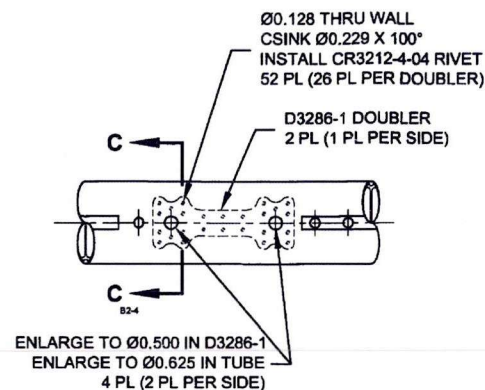
Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐									
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval							
Description Work Order Deviation			Disposition								
			Completed By								
			Lead hand / Supervisor Approval Verification								
			QC / QA Coordinator Approval								
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OTHER : ☐											

RELEASED
UP 09.02.07

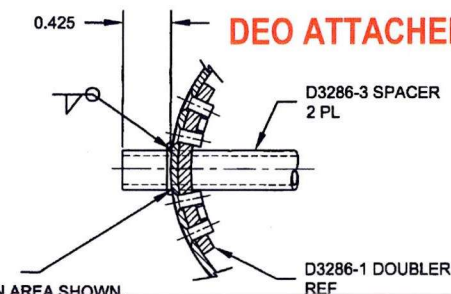
DEO ATTACHED



DETAIL A D6-2
C2-2
D6-3
C2-3
SCALE NONE

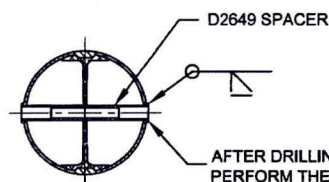


DETAIL B C3-2
C3-3
SCALE NONE



- TO INSTALL D3286-1/-3:
1. GRIND OFF FLANGE IN AREA SHOWN, FLUSH WITH OUTSIDE SURFACE OF ROUND TUBE
 2. LOCATE & DRILL D3286-1 DOUBLER USING DT3286-1T1
 3. ENLARGE HOLES IN D3286-1 TO Ø0.500
 4. ENLARGE HOLES IN TUBE TO Ø0.625 AND CHAMFER HOLE 0.03 X 45°
 5. RIVET D3286-1 TO TUBE
 6. INSERT D3286-3 SPACER
 7. WELD IN PLACE AND GRIND FLUSH

SECTION C-C C6-4
PARTIAL SECTION
SCALE NONE



SECTION D-D A4-2
A4-3
FOR Ø0.375 HOLES ONLY
SCALE NONE

- AFTER DRILLING AND BENDING ASSEMBLY PERFORM THE FOLLOWING FOR Ø0.375 HOLES ONLY:
1. CHAMFER HOLE 0.03 X 45°
 2. INSERT D2649 SPACER
 3. WELD INTO PLACE AND GRIND FLUSH
 4. CBORE TO Ø0.313 X 0.75 DP (EXCEPT WHERE INDICATED)

DESIGN	91	DART AEROSPACE USA, INC	
DRAWN	91	PORT HADLOCK, WA	
CHECKED	91	DRAWING NO. D3804	REV. A
MFG. APPR.	91	SHEET 4 OF 5	
APPROVED	91	TITLE	SCALE
DE APPR.	91	SKIDTUBE ASSEMBLY, 206A/B	NTS
DATE	08.07.07	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

QQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

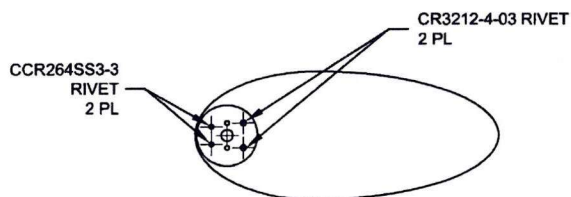
QA Closed: _____ Date: _____

Work Order update only ☐

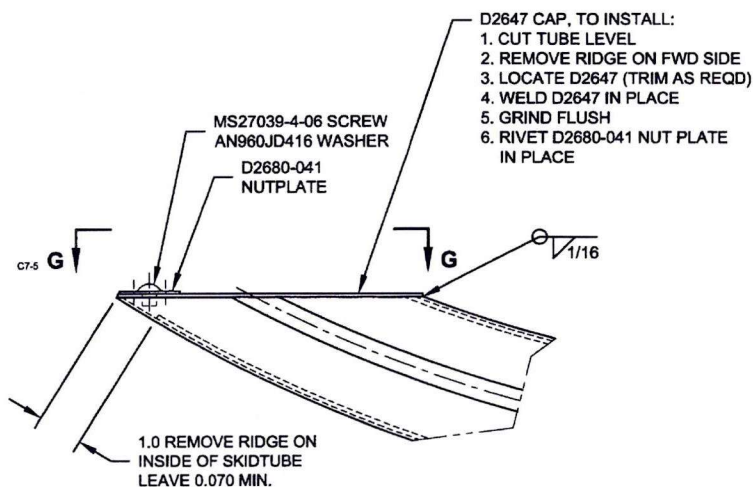
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

RELEASED
99 07.03.03

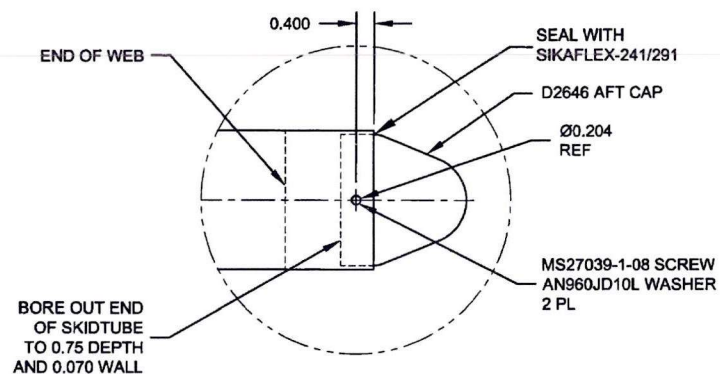
DEO ATTACHED



VIEW G-G
SCALE NONE A7-5



DETAIL E
SCALE NONE B7-2 B7-3



DETAIL F
SCALE NONE B2-2 B2-3

DESIGN	99	DART AEROSPACE USA, INC	
DRAWN	J	PORT HADLOCK, WA	
CHECKED	9	DRAWING NO.	REV. A
MFG. APPR.	B	D3804	SHEET 5 OF 5
APPROVED	99	TITLE	SCALE
DE APPR.	99	SKIDTUBE ASSEMBLY, 206A/B	NTS
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QQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

DRAWING NO. D3804	TITLE SKIDTUBE ASSEMBLIES, 206A/B	REV. A	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3804-A-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AD	CHECKED A.P.	DATE 12.10.22	MFG. APPR. [Signature]	APPROVED [Signature]	DATE 12.10.22	DE APPR. [Signature]	
DATE 12.10.12	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22	DATE 12.10.22	

PURPOSE:
CHANGE C'BORED WELDED CROSSBOLT SPACERS TO SWAGED SPACERS

CHANGE:
PARTS LIST IS AMENDED AS FOLLOWS:

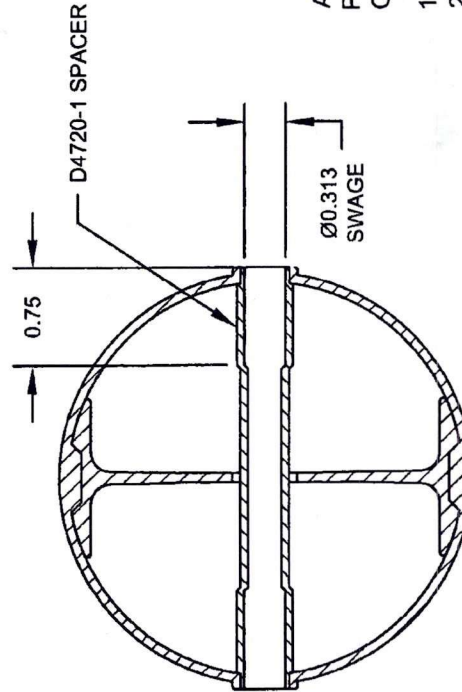
IS:

QTY	QTY	PART NUMBER	DESCRIPTION
-041	-043		
1	1	D2649	CROSS BOLT SPACER
18	19	D4720-1	SPACER

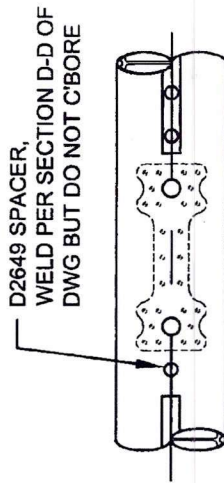
WAS:

19	20	D2649	CROSS BOLT SPACER
----	----	-------	-------------------

ADD SECTION H-H BELOW, WHICH IS THE SAME SECTION VIEW AS SECTION D-D OF DWG. C'BORED HOLES ARE NOW SWAGED PER SECTION H-H BELOW. FOR THE Ø0.375 HOLE THAT IS NOT C'BORED, WELD PER SECTION D-D OF DWG (SEE AMENDED DETAIL B FOR REFERENCE).



SECTION H-H
FOR Ø0.375 HOLES ONLY
FOR HOLES THAT ARE CURRENTLY C'BORED ONLY
NOT TO SCALE



DETAIL B
AMENDMENT TO DETAIL B
NOT TO SCALE

RELEASED
2012-11-16

AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375 HOLES THAT ARE
CURRENTLY C'BORED:

1. INSERT D4720-1 SPACER, 18 PL (-041) OR 19 PL (-043)
2. SWAGE TO Ø0.313 X 0.75 DP PER QSI 002
3. TRIM / GRIND FLUSH PER QSI 002

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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